

Date: Wednesday, 4/4/2007 9:03:42 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BUSHING		
Job Number	: 31610		Part Number	: D26175		
Estimate Number	: 10310		Drawing Number	: D2617 REV D2		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 4/4/2007	S.O. No. : N/A	Drawing Revision	: D2		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 4/15/2007		
Previous Run	: 31033		Qty:	30	Um:	Each
Written By	:		Comment	:		
Checked & Approved By	:		Est H	04.07.14	Reformat; added step 5 KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6T0500W058	6061-T6 Tube .500 x.058W
Comment: Qty.: 0.0205 f(s)/Unit Total : 0.6143 f(s) 6061-T6 Round Bar 1.5" Material: 6061-T6 (QQ-A-225/8 or QQ-A-200/8 or WW-T-700/6) Ø0.500" tubing x 0.058" wall M6061T6T0.500W.058) Batch <u>1106007</u>		
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
Comment: HARDINGE CNC LATHE SMALL 1-Machine as per Folio FA438 and Dwg D2617 2-Deburr		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK		
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/04/24
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/4/2007 9:03:42 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 31610

Part Number: D26175

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

E. Bottay/23

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

E. Bottay/23 35

8.0 QC21

FINAL INSPECTION/W/O RELEASE



35

Comment: FINAL INSPECTION/W/O RELEASE

E. Bottay/24

Job Completion



4/4/2007

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31610
Description: Bushing	Part Number:	D2617-5
Inspection Dwg: D2617	Rev: D2	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

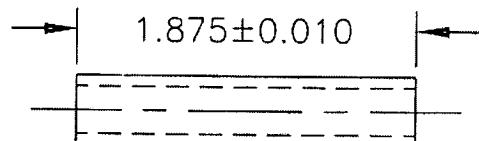
Measured by: <u>J. S.</u>	Audited by: _____	Prototype Approval: N/A
Date: <u>07/04/17</u>	Date: _____	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.08.09	New Issue	KJ/JLM	
B	06.03.08	Dwg Rev change	KJ/JLM	

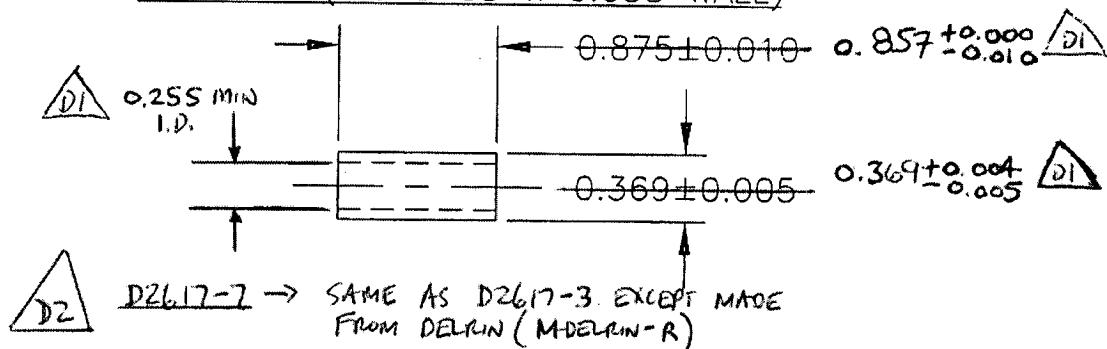


DESIGN	BW	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED #	DRAWING NO. D2617	REV. D SHEET 1 OF 1
DATE 01.07.04		TITLE BUSHING		SCALE 1:1
D2	04.09.10	ADD D2617-7		
A	96.10.08	NEW ISSUE		
B	97.05.08	.875 WAS 1.125		
C	97.06.04	0.369 DIA WAS 0.375		
D	01.07.04	ADD MAT'L SPEC AND TOL./DIM. NOTE		
DI	IP-# 04.07.12	CORRECT TOLERANCE (NCR 779)		

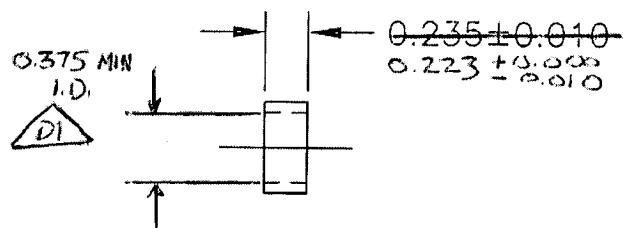
D2617-1 (0.375 OD x 0.058 WALL)



D2617-3 (0.375 OD x 0.058 WALL)



D2617-5 (0.500 OD x 0.058 WALL)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31610

NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES